Work Order II Wednesday, June 15,									Page 1
Item ID: D339 Revision ID:			Accept			iii s	Setup Star		
Start Date: 6/15/ Required Date: 6/22/ Reference:	2011 Start Qty: 40.00			Cust Item I Customer:	D :		Stop	P 	
Approvals: Proc	cess Plan:	Date:	Tooling: SPC (Y/N):		ate:	R	tun Star Stoj		8.16 1 1 1 1 1 1 1 1 1
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3395	Rev A								
Hardinge CNC Lathe Small	Hardinge CNC LATHE Memo Turn as per	SMALL ^{**} Folio FA513 and Dwg D339	0.00 0.00 0.00 0.00	11)6122		40	Ø		
QC Quality Control	QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00	16/22		40	Ø		-
120 QC Quality Control	QC8- Inspect parts - sec	ond check	0.00	(· C · 5	22	40	\$		

Work Order ID 70775

Wednesday, June 15, 2011 9:09:47 AM



Page 2

Item ID:

D3395-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Bushing

Start Date: 6/15/2011 Required Date: 6/22/2011

Start Qty: 40.00

Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan: _____

Operation

Description

Date: Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run

Start Stop



Tool ID

Tool # Plan

Code

Accept Qty

Reject

Reject

Insp.

Sequence ID/ Work Center ID

130



Packaging

Memo

0.00

0.00

Qty

Number Stamp

Packaging

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location

0.00

Memo

0.00

ML6/2394 MF 11-06-23

Picklist Print

Wednesday, June 15, 2011 9:09:54 AM

Work Order ID: 70775

, 0 , 1 , 5

Parent Item: D3395-1

Parent Item Name: Bushing



Start Date: 6/15/2011

Required Date: 6/22/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP A□05.02.23□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.500		Purchased	No			100	f	79.9750	0.0625	2.631579	11)0	6/2	2

Delrin Round Bar .50"

Location	Loc Qty	Loc Code
MAT055	79.975	
109571	29.975	
18355	50	

2-5Pt,

DART AEROSPACE LTD	Work Order:	70775
Description: Bushing	Part Number:	D3395-1
Inspection Dwg: D3395 Rev: A		Page 1 of 1

	FIRS	T ARTICLE IN	NSPECTI	ON CHE	CKLIST		
	>	First Artic	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
0.600	+/-0.010	,602			51-8		
0.060	+/-0.010	-Ob2	/		ſ		
R0.010	+/-0.010	R.015					
0.030 x 20°	0.5°	030X29					
Ø0.500	+/-0.010	04195					
Ø0.191	+0.005/-0.001	01181		_	7		
Ø0.305	+/-0.010	0.305					
Measured by:	5)	Audited by:	60 - T	- 22	Prototype /	Date:	N/A N/A
Rev Date A 05.0714	Change New Issue				Ro K	evised by	Approved

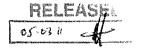
Dart Aerospa	ce	Ltd
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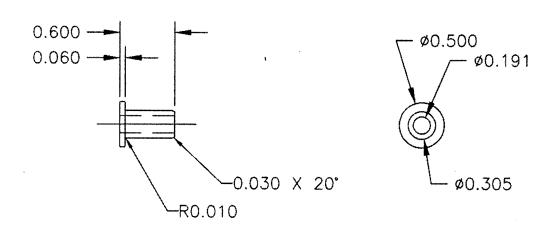
W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		· · · · · · · · · · · · · · · · · · ·											
				,									
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:					
Resolution:			Disposition: Q			losed:	Date:						
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)							
DATE	STEP	Description of NC			Section B Veri			ification Approval					
DAIL	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC inspector				
		·											
	,												

NOTE: Date & initial all entries



DESIG	CP	DRAWN BY	DA	ART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	-
CHECH	ED #	APPROVED	DRAWING NO.	SHEET	REV. A
DATE		T 11/4	TITLE		SCALE
05.0	3.10		BUSHING		1:1
 Α		05.03.10	NEW ISS	JE .	





SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 70775

D3395-1 BUSHING

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace I	Lta
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W/O:			W	ORK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CH	EDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					~~				
Part No	:	PAR #:	Fault Cat	egory:	ICR: Yes	No DQ	\ :	_ Date: _	
Resolution:			Dispositi	on: (A: N/C Closed:			Date:	
NCR:			WORK ORI	DER NON-CONFORMAN	CE (NCF	₹)		<i>;</i>	
DATE	STEP	Description of NC		Verificati			n Approval	Approval	
	J	Section A 5	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector
			:						
			·						
					·				
			·						

NOTE: Date & initial all entries